

# Work Order ID 64173

Friday, November 26, 2010 4:14:16 PM



Page 1

Item ID: K642-512

Accept



Setup Start



Revision ID:

Item Name: saddle kit 642-512

Stop



Start Date: 11/29/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 10-11-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Create White labels per PPP K642-512 CHG004

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*Handwritten:* After BG 10-11-30

*Handwritten:* 10 12 09 (3)

*Handwritten:* 10/11/30 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64173**

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Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 11/29/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

MA 10 12 09 (3)

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-512 Location: PK

Reva

11/10/10 30 3K

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09

10-12-9 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 64173

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00


Comments: IPP Rev:A 05.06.07 new issue EC  
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A  x3 BOLT		Purchased	No			110	Each	97.0000	3 	9			

Location	Loc Qty	Loc Code
ST353	97	
111724	1	
112489	16	
114523	30	
116082	50	

AN3C36A  
  
x3 BOLT

Purchased No 110 Each 178.0000

9  
 27  
m116082

Location	Loc Qty	Loc Code
ST353	178	
109771	6	
115882	22	
116050	50	
116202	50	
116239	50	

m116239

10/12/01 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64173

Parent Item: K642-512

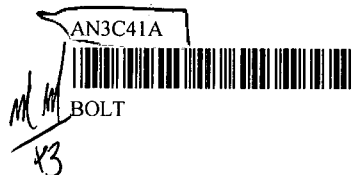
Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00



Purchased No

110 Each

103.0000

8 24

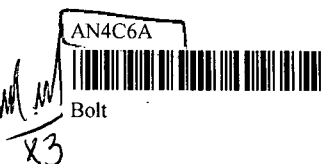
## Location

## Loc Qty

## Loc Code

FG	4	
103324	4	
ST354	99	
114443	17	
115316	32	
116050	50	

115316 2x  
116000 2x



Purchased No

110 Each

429.0000

12 36

## Location

## Loc Qty

## Loc Code

FG	4	
103344	4	
ST356	425	
113121	15	
115016	200	
116003	200	
116075	10	

115016



Purchased No

110 Each

198.0000

8 24

## Location

## Loc Qty

## Loc Code

FG	3	
104817	3	
ST338	195	
114443	14	
114455	70	
114523	61	
116075	50	

114455 22x  
114523 2x

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Work Order ID: 64173

Parent Item: K642-512

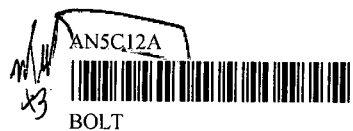
Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00



Purchased

No

110

Each

136.0000



12

## Location

## Loc Qty

## Loc Code

FG

2

18918

2

ST338

134

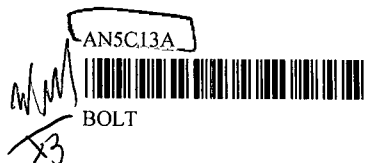
113121

42

116075

92

11/6075



Purchased

No

110

Each

154.0000



12

## Location

## Loc Qty

## Loc Code

FG

2

18918

2

ST338

152

113121

2

114615

50

116075

100

11/4615



Purchased

No

110

Each

74.0000



3

## Location

## Loc Qty

## Loc Code

ST339

74

111819

74

11/1819

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64173

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00



Purchased No

110 Each

76.0000



6

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

72

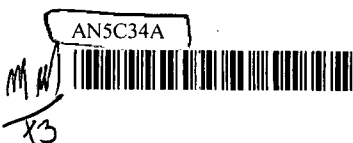
111808

22

113164

50

m111808 50  
m113164 10



Purchased No

110 Each

90.0000



6

Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

88

111648

28

112454

60

m111648



Purchased No

110 Each

86.0000



3

Location

Loc Qty

Loc Code

ST340

86

108084

40

108407

46

m108084

Ca 12/14/30 (3)

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64173

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN960C10L NAS1149C0332 Purchased  
R  
washer

No

110

Each

25.0000

24

72

## Location

## Loc Qty

## Loc Code

ST245

25

107534

25

110

Each

19.0000

24

72

AN960C416L NAS1149C0332 Purchased  
R  
WASHER

## Location

## Loc Qty

## Loc Code

ST346

19

112828

19

110

Each

6.0000

8

24

AN960C316L NAS1149C0532 Purchased  
R  
WASHER

## Location

## Loc Qty

## Loc Code

ST347

6

111916

6

110

Each

10.0000

1

3

D206-648-01 Manufactured  
GHW Modification

No

## Location

## Loc Qty

## Loc Code

FG120

10

63860

10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64173

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

*M/W*  
x3 **D2652**  
Bushing

Manufactured No

110

Each

79.0000

**16**  
48  
63991

48

*Cody/12/10*

## Location

## Loc Qty

## Loc Code

FG

44

31985

44

ST020

35

61645

1

63311

34

Manufactured No

110

Each

338.0000

**10**  
30

30

*B*

*M/W*  
x3 **D2712**  
Set Screw

## Location

## Loc Qty

## Loc Code

FG

50

29962

50

ST022

288

61331

288

Manufactured No

110

Each

15.0000

**1**  
3

3

*C*

*M/W*  
x3 **D2932-2**  
Saddle RH Out, 206

## Location

## Loc Qty

## Loc Code

ST421

1

62637

1

ST428

8

52586

6

60253

2

ST428A

6

62080

6

Manufactured No

110

Each

0.0000

**1**  
3

3

*B62081 12/12/10 SP 3X*

*M/W*  
x3 **D2933-2**  
Saddle RH In, 206

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64173

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

*WJ*  
x3  
D2934  
Saddle Spacer

Manufactured No

110 Each

45.0000

*2*  
6

Location

Loc Qty

Loc Code

FG

6

31929

6

ST028

39

63559

39

Manufactured No

110 Each

63.0000

*2*  
6

Location

Loc Qty

Loc Code

ST028

63

62690

37

63558

26

Manufactured No

110 Each

4.0000

*1*  
3

Location

Loc Qty

Loc Code

ST428A

4

62820

4

Manufactured No

110 Each

1.0000

*1*  
3

Location

Loc Qty

Loc Code

ST428A

1

58268

1

*WJ*  
x3  
D2938-2  
Saddle RH Out, 206

*WJ*  
x3  
D2939-2  
Saddle RH In, 206

*62820 2x*

*B62002 10/12/15 (30)*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64173

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00



D3396-3

Spacer

Manufactured No

110

Each

53.0000



2

6

*li*

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

43

58680

3

63557

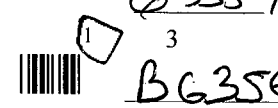
40

Manufactured No

110

Each

4.0000



1

3

63557

B63567 10/12/28

Location

Loc Qty

Loc Code

ST420

3

62627

3

ST464

1

50387

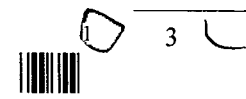
1

Manufactured No

110

Each

24.0000



1

3

*Ce 11/30 (3)*

Location

Loc Qty

Loc Code

ST058

24

63239

24

63239



D3407-043

Tow Ring



D3456-1

Washer

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 64173

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3457-1



Washer

Manufactured No

110

Each

39.0000



6

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

29

45913

1

62691

28

Manufactured No

110

Each

653.0000



72

Location

Loc Qty

Loc Code

ST077

653

42329

10

52505

643

Manufactured No

110

Each

327.0000



72

Location

Loc Qty

Loc Code

ST077

327

57704

327

Manufactured No

110

Each

388.0000



72

Location

Loc Qty

Loc Code

ST077

388

53237

388

D3672-3



Phenolic Washer

Manufactured No

110

Each

327.0000



72

D3672-7



Phenolic Washer

Manufactured No

110

Each

388.0000



72

Location

Loc Qty

Loc Code

ST077

388

53237

388

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W/O:		WORK ORDER CHANGES					
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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

MS21043-3



Nut

X3

Purchased No

110 Each

2,116.000

20 60

Location

Loc Qty

Loc Code

FG

76

103691

76


ST301

2040

112314

2040

MS21043-4



Nut

X3

Purchased No

110 Each

1,075.000

13 39

Location

Loc Qty

Loc Code

ST301

1075

114523

23

114784

152


115936

300

116188

600

MS21043-5



Nut

X3

Purchased No

110 Each

552.0000

4 12

Location

Loc Qty

Loc Code

ST301

552

111819

52

112314

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



### 32.17 206L/L-1/L-3/L-4/407 High Gear Float Skidtubes (Tri-Bag Compatible) Parts List

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			AN3C4A	* BOLT <sup>(1)</sup>
5A			2			AN960C10L	* WASHER <sup>(1)</sup>
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (OR AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4				AN5C11A (OR AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET <sup>(1)</sup>
23A			1	1		D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET <sup>(1)</sup>
24A			1	1		D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET <sup>(1)</sup>
25A			1	1		D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET <sup>(1)</sup>
26A			78	78		AN3C4A	* BOLT <sup>(1)</sup>
26B			78	78		AN960C10L	* WASHER <sup>(1)</sup>
26C			78			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE  
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

REFERENCE ONLY

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